

Date: Friday, 9/14/2007 2:00:51 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : LUG
Job Number : 34671B	
Estimate Number : 10841	
P.O. Number : <i>N/A</i>	Part Number : D22493
This Issue : 9/14/2007 S.O. No. : <i>N/A</i>	Drawing Number : D2249 REV. E
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : SMALL /MED FAB	Drawing Revision : E
Previous Run : 31609B	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 10/20/2007
Checked & Approved By : <i>[Signature]</i>	Qty: <i>30</i> Um: Each
Comment : Est: D 05.02.04 Added Step 9 KJ/RF	
Est Rev:E Now On Waterjet 07-03-08 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S16GA	304/316 .063 Sheet
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Comment: Qty.: 0.1470 sf(s)/Unit Total : 1.4700 sf(s)
 304/316 .063 Sheet

Batch: *M101873 B 07-09-19 M105130*

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D2249

Dwg Rev: *E* *B 07-09-19*

Prog Rev: *E*

2-Deburr if necessary *B 07-09-19*

(38)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

E 07/09/20

(38) counter

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
 Form as per Dwg D2249

SB 07/09/27

(38)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: PD Date: 09/09/22
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 9/14/2007 2:00:51 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG

Job Number: 34671B

Part Number: D22493

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



center

Comment: INSPECT WORK TO CURRENT STEP

En 07/09/27 (38)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

PAT

07/15/28

(38)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



(39)

Comment: FINAL INSPECTION/W/O RELEASE

07/09/28

Job Completion



U 07/09/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

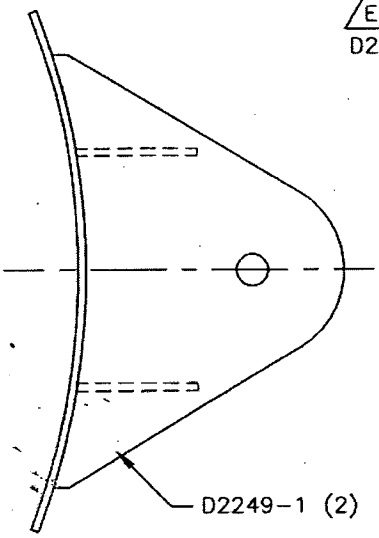
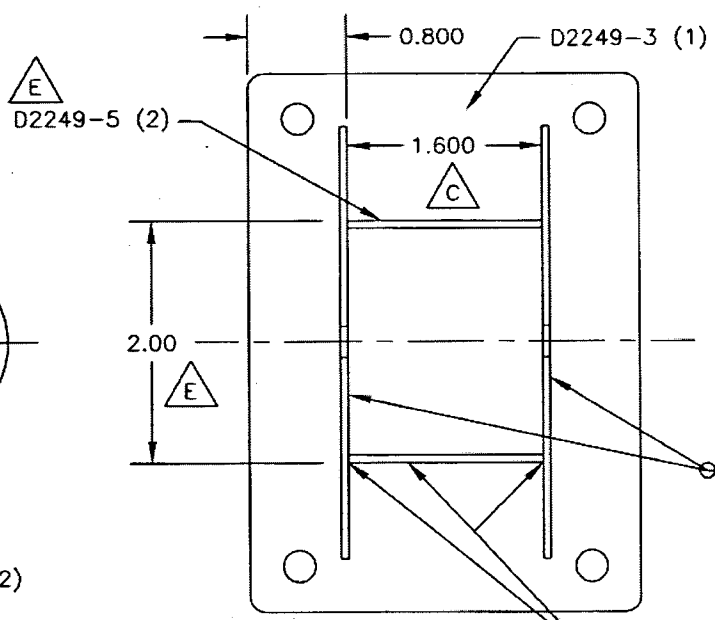
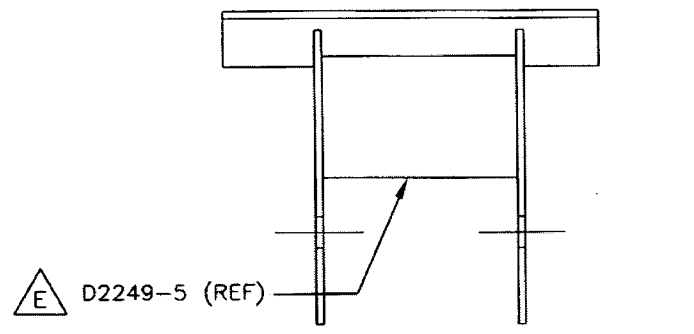
NOTE: Date & initial all entries

DART



RELEASED
99.10.12 KZ

DESIGN	AE	DRAWN BY	RF	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA
CHECKED	AE	APPROVED	[Signature]	DRAWING NO. D2249
DATE	99.09.20	TITLE	FITTING	REV. E SHEET 1 OF 4
A	94.06.20	NEW ISSUE		SCALE NTS
B	95.11.30	DIMENSION CHANGE		
C	95.12.14	DIMENSION CHANGE		
D	98.04.30	Ø0.261 WAS Ø0.257 (TSR A179) REMOVED DUPLICATE DIMENSIONS		
E	99.09.20	ADDED GUSSET		



D2249-041 ASSEMBLY

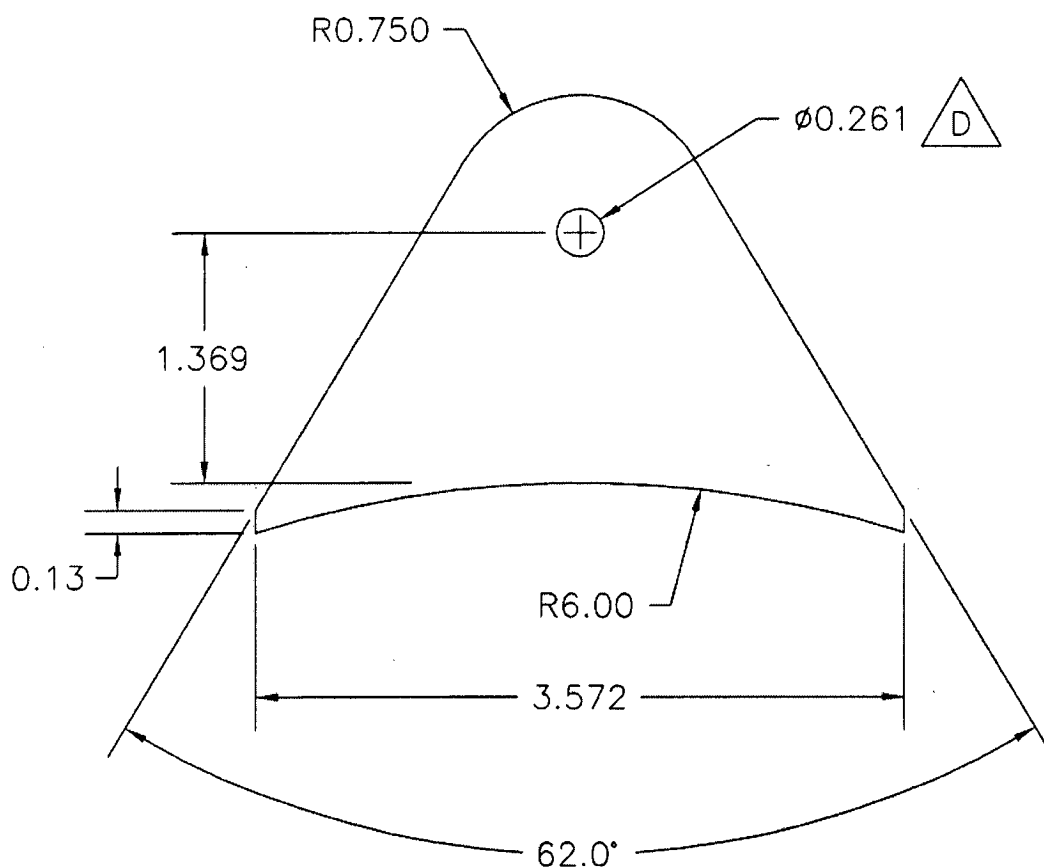
MATERIAL: AISI 304/316 SS, 0.063 THICK
WELD PER DART QSI 004
FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
ALL DIMENSIONS ARE IN INCHES
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE SPECIFIED

SHOP COPY
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WITHOUT NOTICE
WORK ORDER
NO. 34671 B



DESIGN <i>KE</i>	DRAWN BY <i>RF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2249	REV. E SHEET 2 OF 4
DATE 99.09.20		TITLE FITTING	SCALE 1:1

RELEASED
99.10.12 KE



D2249-1 LUG

MATERIAL: AISI 304/316 SS 0.063 THICK
ALL DIMENSIONS ARE IN INCHES

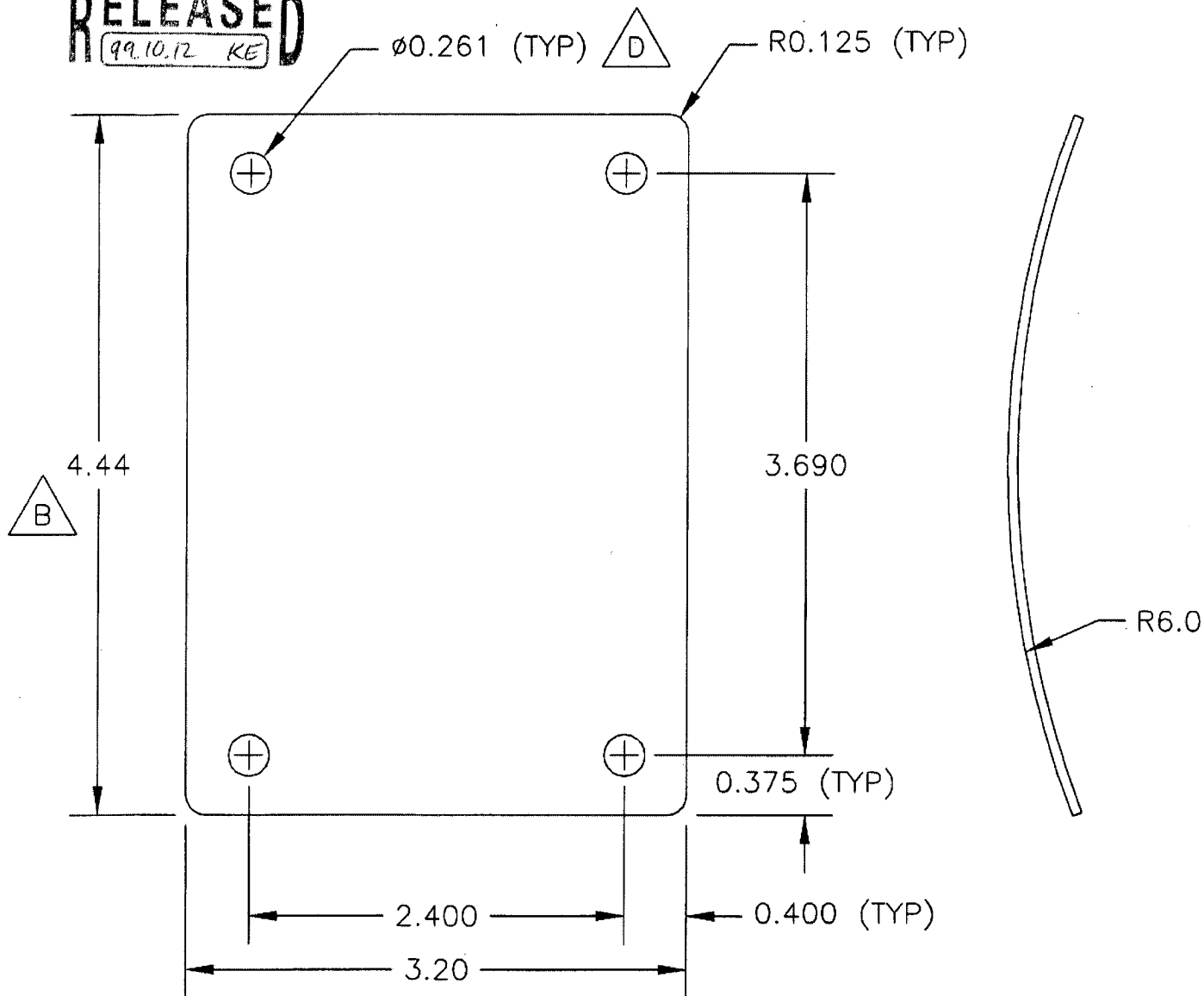
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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CHECKED <i>KE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2249	REV. E SHEET 3 OF 4
DATE 99.09.20	TITLE FITTING		SCALE 1:1

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99.10.12 KE



FLAT PATTERN

D2249-3 BASE PLATE

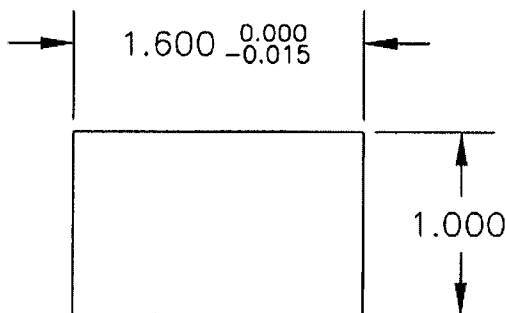
MATERIAL: AISI 304/316 SS 0.063 THICK
ALL DIMENSIONS ARE IN INCHES
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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WORK ORDER
NO. 34671B



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CHECKED <i>KE</i>	APPROVED <i>RF</i>	DRAWING NO. D2249	REV. E SHEET 4 OF 4
DATE 99.09.20		TITLE FITTING	SCALE 1:1

RELEASED
19.10.12 *KE*



D2249-5 GUSSET

MATERIAL: AISI 304/316 SS 0.063 THICK

ALL DIMENSIONS ARE IN INCHES

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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NO. *34671E*